

Work Order ID 136447

Wednesday, September 02, 2015 3:27:15 PM

136447

Page 1

Item ID: D4366-041 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Run-on Landing Wearplate Fwd
Start Date: 9/1/2015 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 9/1/2015 Req'd Qty: 1.00 ***1*** Customer:
Reference:

Approvals: Process Plan: MLS Date: SEP 01 2015 Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4366	B								

110

0.00

110

Large Fab

Large Fab

Memo

0.00

***FRONT BENT (1.37) COULD BE OVER BENT HIGHER BY 0.25"-
0.50"***

1- On D4367-1, fill cut outs with hardcoat welding rod as per dwg D4366
DT9756

2059 B Hardcoat Welding Rod
BATCH#: m130145

2- Weld D4367-1 to wearplate by positioning holes together as per dwg D4366
304 S.S. Welding Rod
BATCH #: m126014

3- Transfer drill holes in bar and cut extra material on bar if necessary

x1 MR 16-02-03

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																															
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Page 2

Item ID:	D4366-041	Accept	*N900040100*	Setup	Start	*NS1*
Revision ID:						
Item Name:	Run-on Landing Wearplate Fwd				Stop	*NS2*
Start Date:	9/1/2015	Start Qty: 1.00	*1*	Cust Item ID:		
Required Date:	9/1/2015	Req'd Qty: 1.00	*1*	Customer:		
Reference:						

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____ **Run** **Start** ***NR1***
 QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____ **Stop** ***NR2***

[illegible]

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
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Work Order ID 136447

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Item Name: Run-on Landing Wearplate Fwd
Start Date: 9/1/2015 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 9/1/2015 Req'd Qty: 1.00 ***1*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	QC5- Inspect part completeness to step on W/O	0.00							
150									DAS 38 9-09
QC	Memo	0.00				①			FEB 10 2016
Quality Control									
160	Identify as per dwg & Stock Location: <i>Post</i>	0.00							
160									
Packaging	Memo	0.00				1			DAS 6 9-09
Packaging									FEB 11 2016
170	QC21- Final Inspection - Work Order Release	0.00							
170									FEB 16 2016
QC	Memo	0.00				MLJ			
Quality Control									

MLJ FEB 11 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
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Wednesday, September 02, 2015 3:27:19 PM

136447

D4366-041

Required Date: 9/1/2015

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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x1. MR 16-02-02

Loc Code

9

/128063

9

10.0000

—

xl re 16-01-26

Loc Code

WA001

10

/108827

4

112429

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition			
				Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
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OTHER : ☐					

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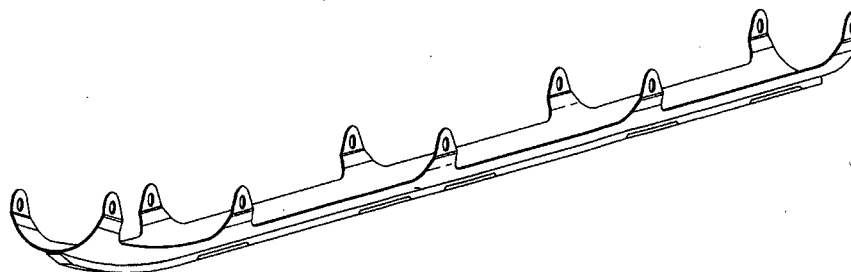
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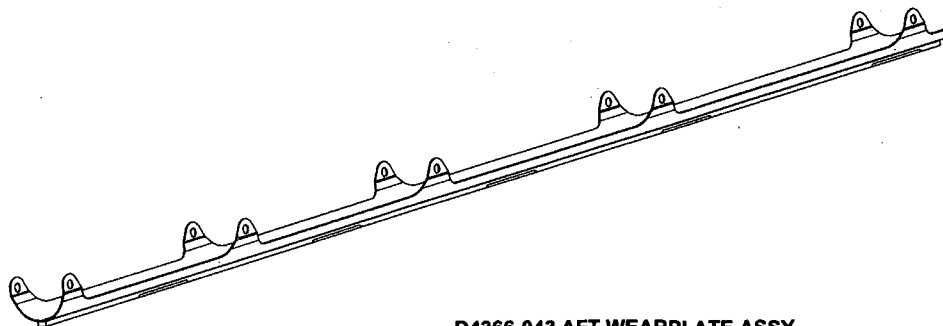
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1



D4366-041 FWD WEARPLATE ASSY



D4366-043 AFT WEARPLATE ASSY

ITEM	QTY -041	QTY -043	PART NUMBER	DESCRIPTION
	X		D4366-041	FWD WEARPLATE ASSY
		X	D4366-043	AFT WEARPLATE ASSY
1	1		D4366-1	PLATE
2		1	D4366-3	PLATE
3	1		D4367-1	BAR
4		1	D4367-3	BAR
5	A/R	A/R	2059B	HARDCOAT
6	A/R	A/R	TEXTURED COATING	SEALANT

△B

136447 MJS
15-09-04

RELEASED
2014-04-17
mjp

B	TEXTURED COATING WAS ROCKGUARD 4714 (BOM TABLE), REVISE NOTE 10 (SH 2).	DB	13.11.04
A	NEW ISSUE	SC	11.06.14
REV.	DESCRIPTION	BY	DATE
DESIGN	SC	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
DRAWN	DB		
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D4366	SHEET 1 OF 5
APPROVED		TITLE	SCALE
DE APPR.		WEARPLATE ASSY	NTS
DATE	13.11.04	COPYRIGHT © 2011 BY DART AEROSPACE USA INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA INC.	

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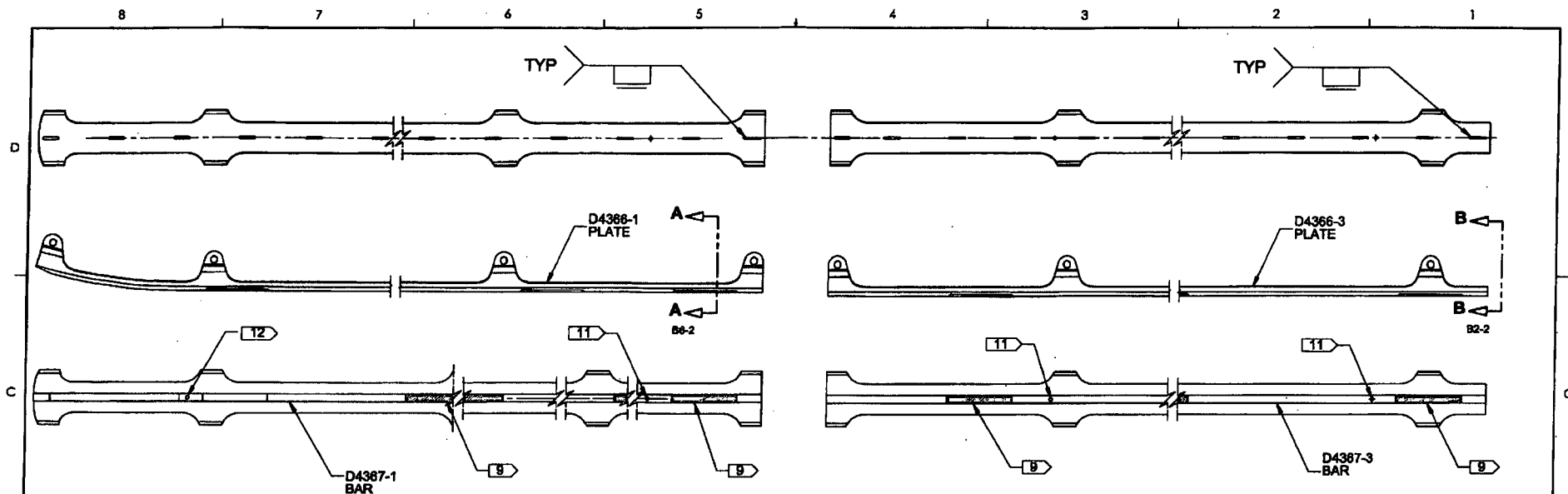
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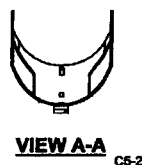
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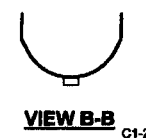


D4366-041 FWD WEARPLATE ASSY

D4366-043 AFT WEARPLATE ASSY



VIEW A-A
C5-2



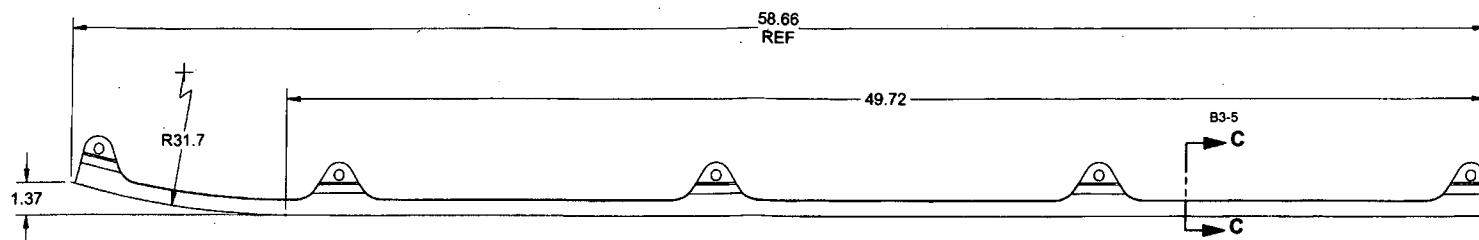
VIEW B-B
C1-2

NOTES:

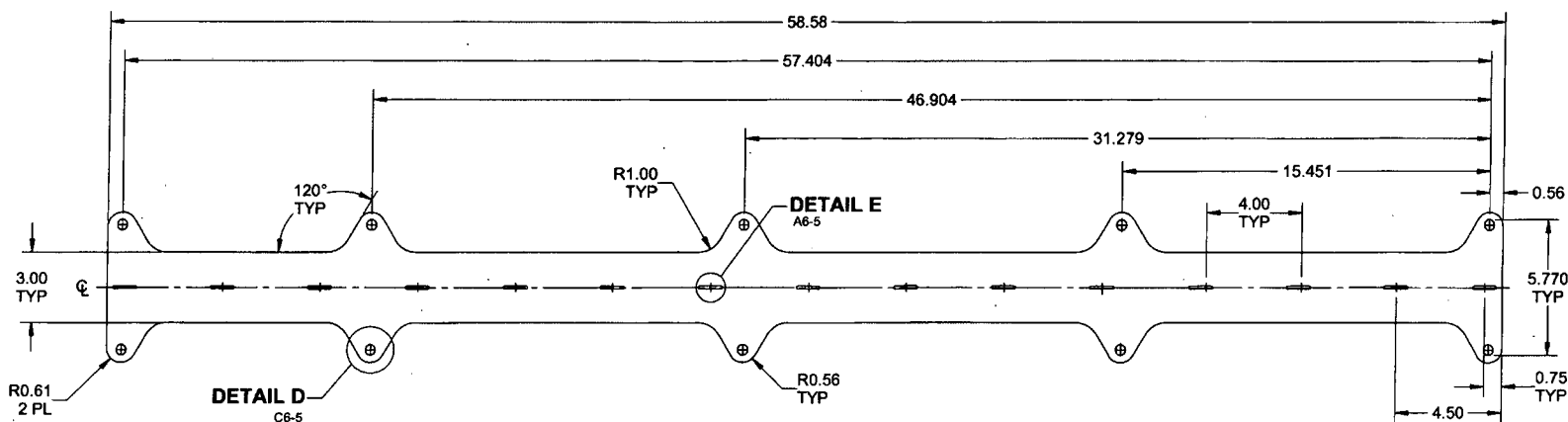
- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4366-04X" PER QSI 044 6.1
- 7) WEIGHT: D4366-041 = 5.30 lbs; D4366-043 = 6.56 lbs
- 8) WELDING: PER QSI 004
- 9) 2059B HARDCOAT WELD, 0.19 THICK X 0.50 WIDE, FLUSH WITH D4367-X BAR ON ALL 3 SURFACES
- 10) COAT ENTIRE TOP (CONCAVE) SURFACE WITH TEXTURED COATING, 0.020 - 0.040 THICK, PER DART QSI 005 4.9.
- 11) TRANSFER DRILL $\varnothing$ 0.188 HOLES FROM D4367-X BAR TO D4366-X WEARPLATE AFTER WELDING
- 12) FILL TOOLING HOLE WITH WELD ONE PLACE ONLY

RELEASED
2014-04-17

DESIGN	SC	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
DRAWN	DB		
CHECKED		DRAWING NO. D4366	REV. B
MFG. APPR.			SHEET 2 OF 5
APPROVED		TITLE WEARPLATE ASSY	SCALE
DE APPR.			NTS
DATE	13.11.04	COPYRIGHT © 2011 BY DART AEROSPACE USA INC. THIS DOCUMENT IS UNCLASSIFIED AND IS AVAILABLE TO THE PUBLIC ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA INC.	



D4366-1 PLATE
(MAKE FROM D4366-1F)

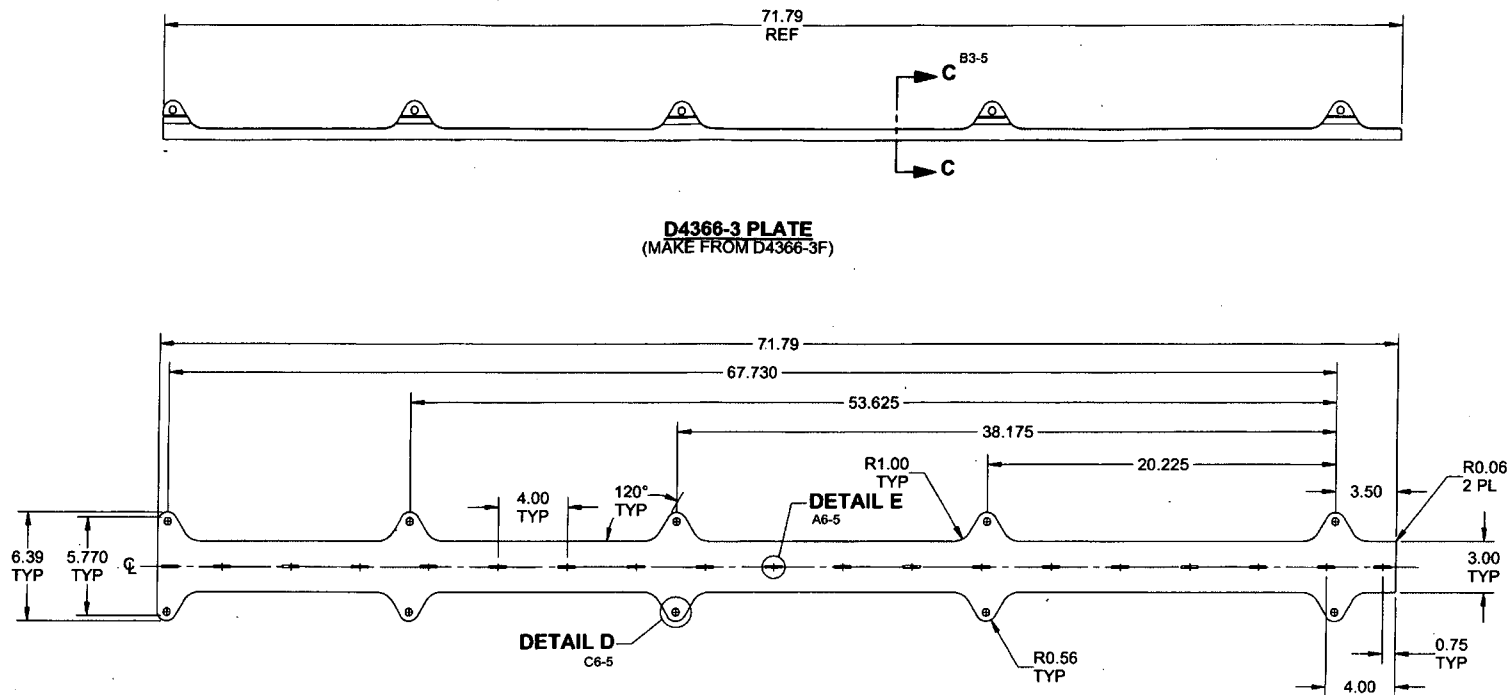


D4366-1F PLATE

RELEASED
2014-04-17

- NOTES:
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET PER AMS 5513 OR 5524 OR ASTM A240 OR ASME SA240 18 GAUGE (0.050 THICK), REF. DART SPEC. M304S18GA
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 2.84 lbs

DESIGN	SC	DART AEROSPACE USA, INC.	
DRAWN	DB	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D4366	SHEET 3 OF 5
APPROVED		TITLE	SCALE
DE APPR.		WEARPLATE ASSY	NTS
DATE	13.11.04	COPYRIGHT © 2011 BY DART AEROSPACE USA INC.	
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D4366-3 PLATE
(MAKE FROM D4366-3F)

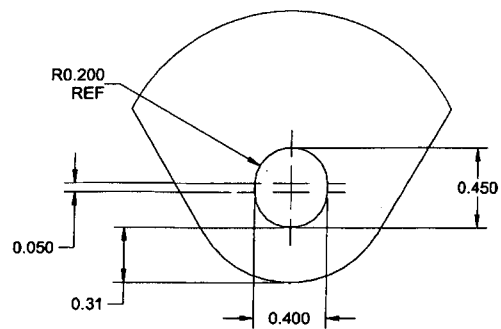
D4366-3F PLATE

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2014 -04- 17
ND

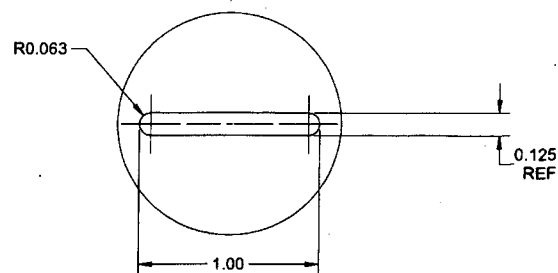
NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET PER AMS 5513 OR 5524
OR ASTM A240 OR ASME SA240
18 GAUGE (0.050 THICK), REF. DART SPEC. M304S18GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 3.41 lbs

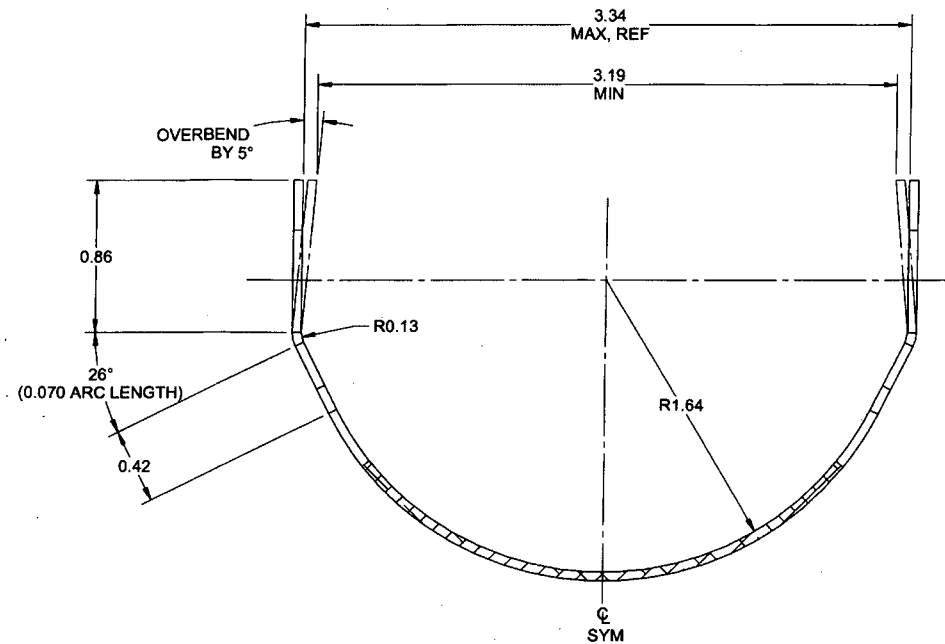
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DRAWN	DB	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D4366	SHEET 4 OF 5
APPROVED		TITLE	SCALE
DE APPR.		WEARPLATE ASSY	NTS
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DETAIL D
SLOT DETAIL TYP
B6-3
B5-4



DETAIL E
SLOT DETAIL TYP
B5-3
B4-4



SECTION C-C
D3-3
D3-4

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2014-04-17

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CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D4366	SHEET 5 OF 5
APPROVED		TITLE	SCALE
DE APPR.		WEARPLATE ASSY	NTS
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